








Work Order ID 53603

November 9, 2009 3:30:39 PM



Page 1

Item ID: D2563 Accept  Setup Start 
 Revision ID: C Stop 
 Item Name: Step Weldment Assembly
 Start Date: 09/11/2009 Start Qty: 4.00  Cust Item ID:
 Required Date: 20/11/2009 Req'd Qty: 4.00  Customer:
 Reference:

Approvals: Process Plan: RL Date: 09/11/09 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____
 Run Start 
 Stop 

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2563	Rev C								

100

0.00



Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut D2244 to 89.70" at 34 deg as per dwg D2563 RL

2-Debur ends RL

3-Weld (1 END CAP, LUG PLATES & MOUNTING ANGLE) as per dwg RL
 D2563 using DT 8343

A/R AL ROD Batch: m111311
m111494 RL

4- Grind RL

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

4 0

PD 09.11.12 (4)

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Item ID: D2563

Accept



Setup Start



Revision ID: C

Stop



Item Name: Step Weldment Assembly

Start Date: 09/11/2009 Start Qty: 4.00



Cust Item ID:

Required Date: 20/11/2009 Req'd Qty: 4.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

4 _____ 09.11.12

130



HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

09.11.16 4 0

140



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

7 M-L 09/11/16 (4X)

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Item ID: D2563

Revision ID: C

Item Name: Step Weldment Assembly

Start Date: 09/11/2009 Start Qty: 4.00

Required Date: 20/11/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Setup Start

Stop

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



Large Fab

Large Fab

Large Fab

Memo

1-Inspect for foreign object per QSI 024

2-Weld Remaining End as per Dwg D2563 using DT 8343

A/R AL ROD Batch: M111311

3-Grind

ph

PL 09-11-17

4 ~~0~~

160



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

0.00

0.00

4 ~~0~~ *BE 09/11/17*

170



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

0.00

0.00

278 09/11/17

(4) ~~0~~

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Item ID: D2563	Accept		Setup	Start	
Revision ID: C				Stop	
Item Name: Step Weldment Assembly					
Start Date: 09/11/2009	Start Qty: 4.00		Cust Item ID:		
Required Date: 20/11/2009	Req'd Qty: 4.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum Memo Touch up Alodine then Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3 START TIME: 7:00AM OVEN TEMPERATURE: 370°F FINISH TIME: 7:30AM	0.00 0.00				(X4)	Ø		
190 HandFinish Hand Finishing	Wing Walk as per dwg QSI005 4.4 Batch 11/12/08 Memo	0.00				(4)			
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00				MD09/11/20	X4		

el 09/11/19

BR 09-11-19

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Item ID: D2563

Revision ID: C

Item Name: Step Weldment Assembly

Start Date: 09/11/2009 Start Qty: 4.00

Required Date: 20/11/2009 Req'd Qty: 4.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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210

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

PAP
53604

0.00

Packaging

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

Picklist Print

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Work Order ID: 53603



Parent Item: D2563RevC



Parent Item Name: Step Weldment Assembly

Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2244-116RevD1		Manufactured	No			100	Each	43.0000	4.0000			
Step Extrusion												

1109.11.10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 43

38023 43

4

D2561RevB Manufactured No



Lug

100 Each 4.0000 8.0000



1109.11.10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST *853616* 4

47177 4

4

D2564RevB1 Manufactured No



Mounting Angle

100 Each 43.0000 8.0000



1109.11.10

Warehouse Loc Qty Loc Code
Location

Main Warehouse

ST 43

47966 43

8

Picklist Print

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Work Order ID: 53603



Parent Item: D2563RevC



Parent Item Name: Step Weldment Assembly



Start Date: 09/11/2009

Required Date: 20/11/2009

Comments:

Start Qty: 4.00

Required Qty: 4.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2673-34RevB		Manufactured	No			100	Each	10.0000	8.0000			
											<i>09.11.10</i>	
End Plate												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

10

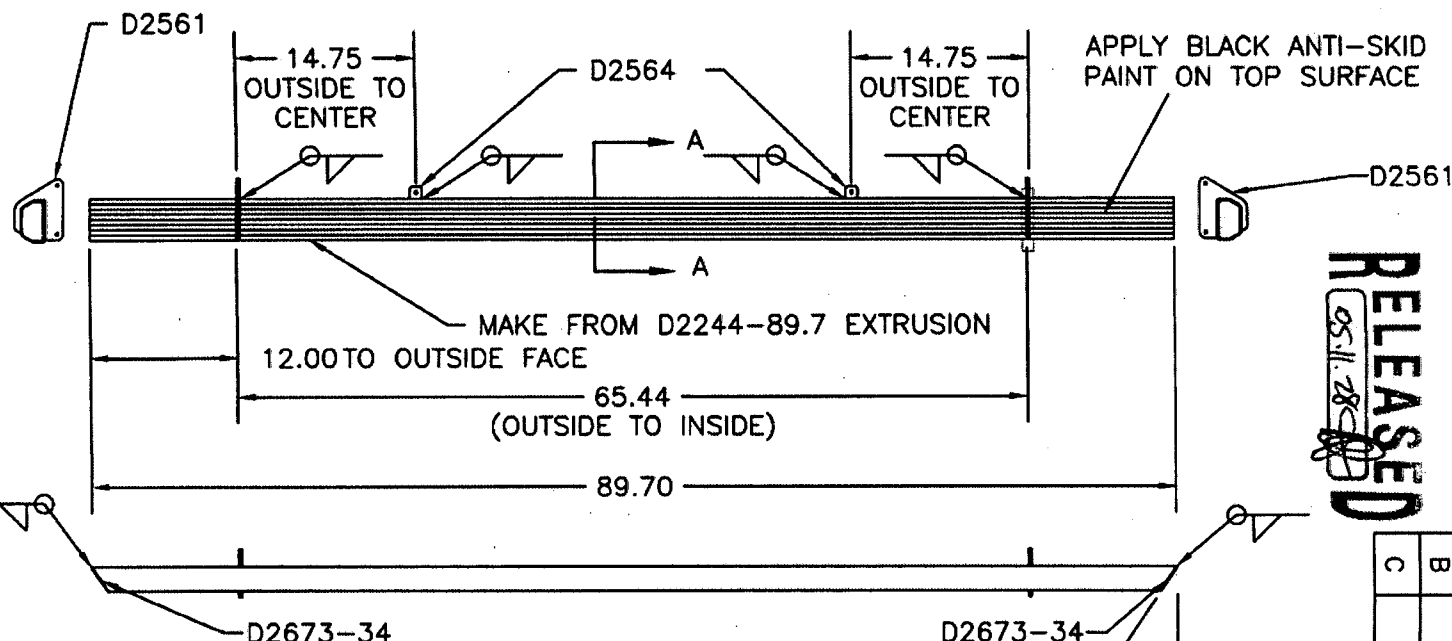
36406

10

8

DART

RELEASED
05.11.28



D2563 STEP WELDMENT ASSEMBLY PARTS LIST

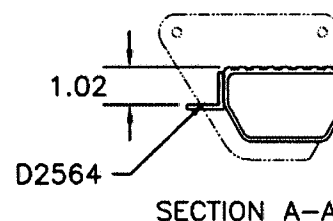
Part No.	Description	QTY
D2563	STEP WELDMENT ASSEMBLY	X
D2244-89.7	EXTRUSION*	1
D2561	LUG PLATE	2
D2564	MOUNTING ANGLE	2

*cut per drawing

D2563 STEP WELDMENT ASSEMBLY NOTES

- 1) MAKE FROM EXTRUSION D2244
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
MASK OFF 0.50 ON EACH SIDE OF D2561 LUGS BEFORE
APPLYING BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. C
BW	dt	HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 1
		D2563	
DATE	TITLE	SCALE	
05.11.14	STEP WELDMENT ASSEMBLY	1:15	
A	96.04.26	NEW ISSUE	
B	97.05.14	END CAPS CHANGED (WAS D2248)	
C	05.11.14	UPDATE NOTES	



SHOWN
R
EN
UNCONTROLLED
SUBJECT TO
WITHOUT
WORK ORDER
NO. 53683
11/02/14